

FIG. 1

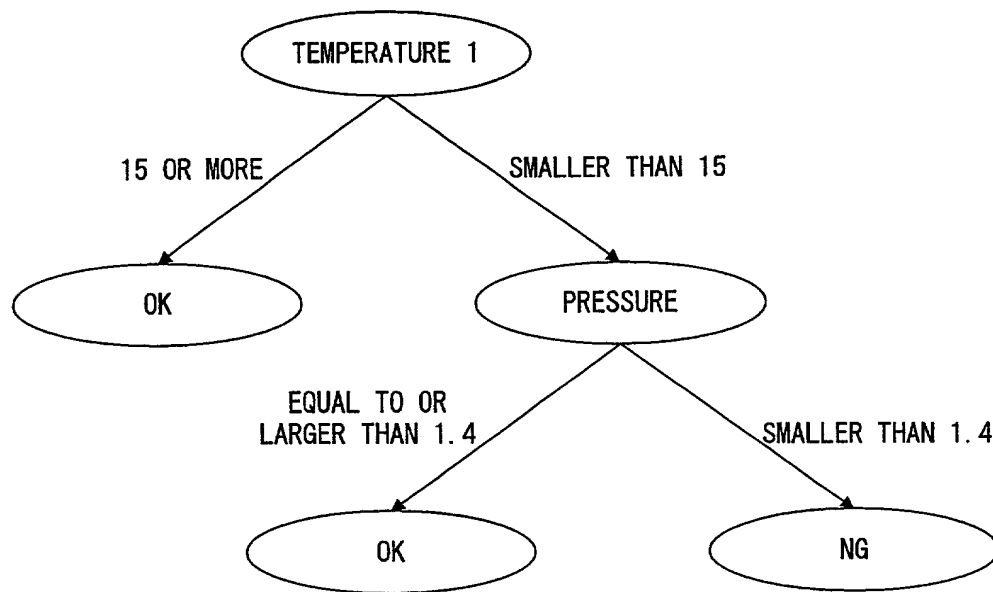


FIG. 2

$[\text{TEMPERATURE } 1 \geq 15] \rightarrow \text{OK}$
 $[\text{TEMPERATURE } 1 < 15] \wedge [\text{PRESSURE} < 1.4] \rightarrow \text{NG}$
 $[\text{TEMPERATURE } 1 < 15] \wedge [\text{PRESSURE} \geq 1.4] \rightarrow \text{OK}$

FIG. 3

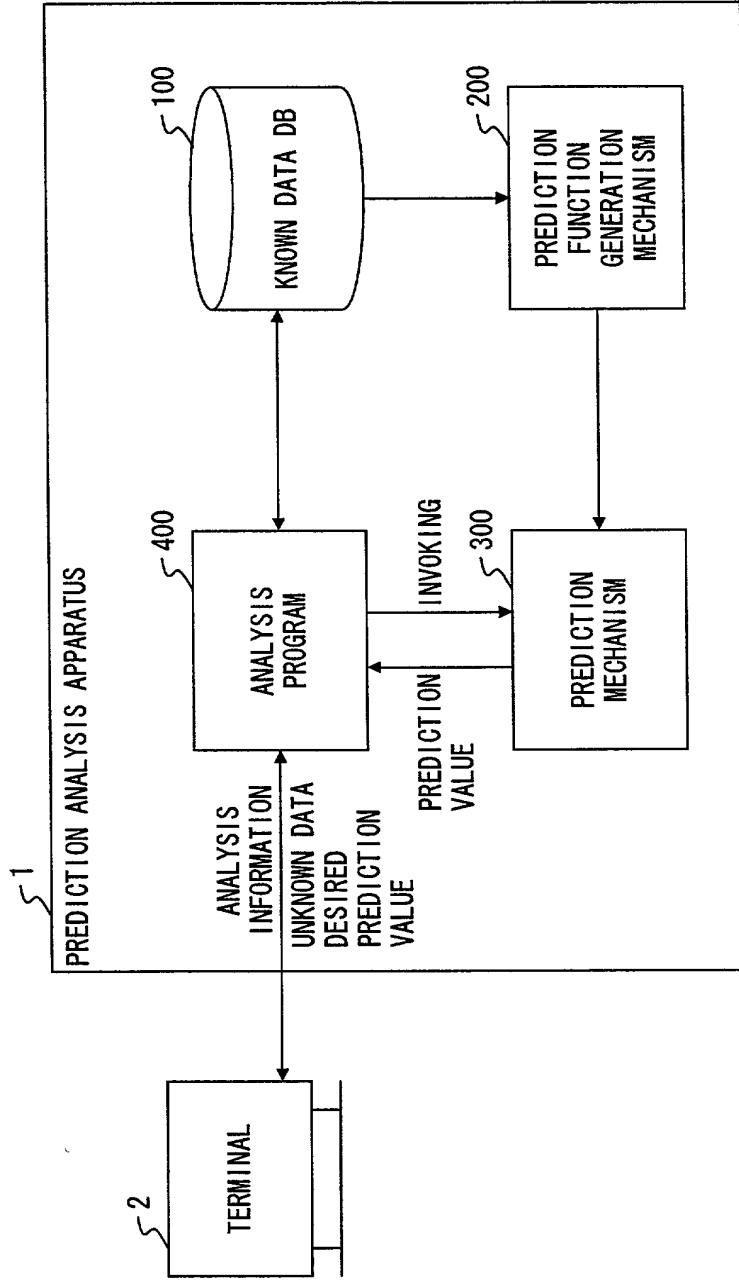


FIG. 4

	TEMPERATURE 1	TEMPERATURE 2	PRESSURE	...	RESULT
No. 1	15.3	10.4	2.0	...	OK
No. 2	13.6	11.5	1.3	...	NG
No. 3	14.9	8.2	1.5	...	OK
:	:	:	:	:	:

FIG. 5A

	TEMPERATURE 1	TEMPERATURE 2	PRESSURE	...	RESULT
No. 101	13.8	8.9	1.9	...	?
No. 102	17.1	12.3	2.2	...	?
:	:	:	:	:	:

FIG. 5B

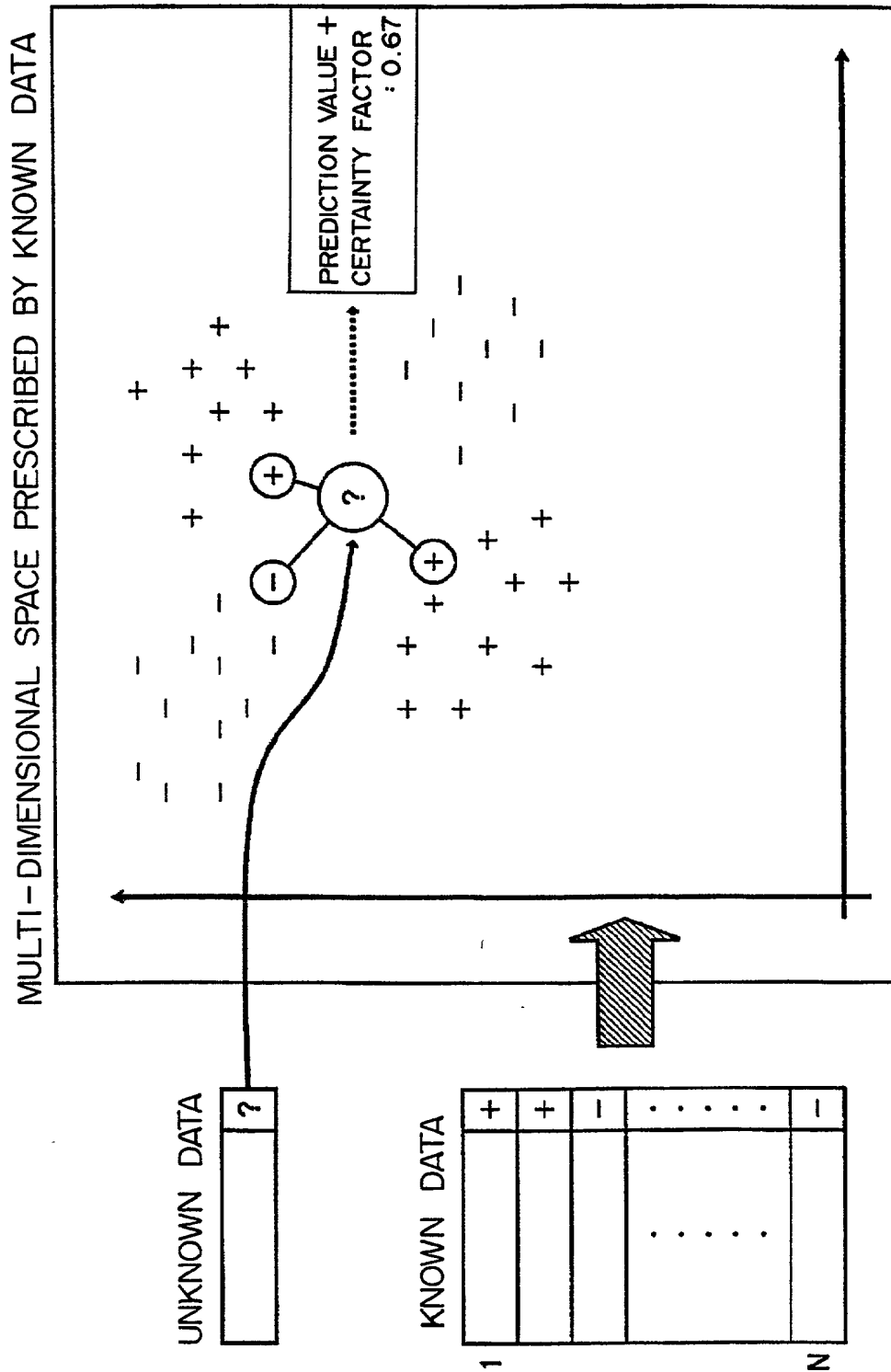


FIG. 6

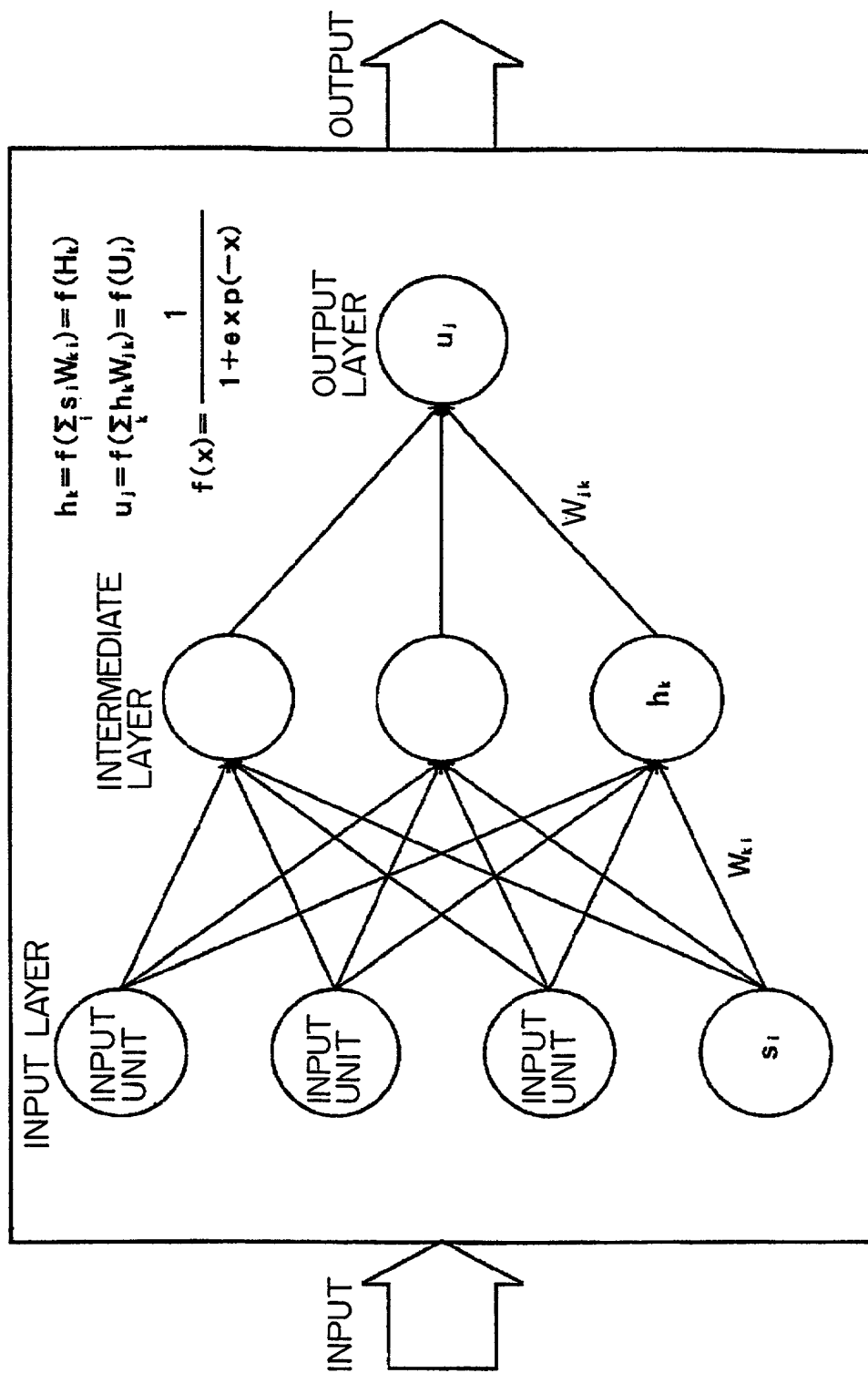
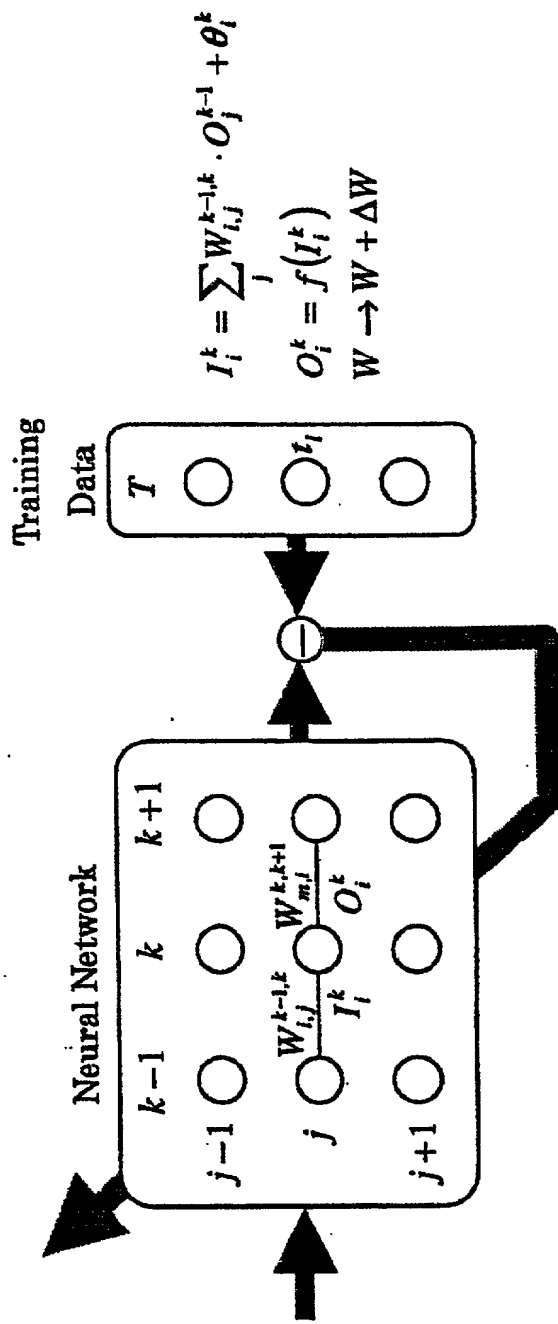


FIG. 7



$W_{i,j}^{k-1,k}$: WEIGHT BETWEEN j UNIT IN (k-1)TH LAYER AND i UNIT IN k LAYER

$W_{m,i}^{k,k+1}$: WEIGHT BETWEEN i UNIT IN k LAYER AND m UNIT IN (k+1) TH UNIT

FIG. 8

$$R = \frac{1}{2} \sum_i (t_i - O_i^n)^2$$

$$\begin{aligned} \Delta W_{i,j}^{k-1,k} &= \varepsilon \left[-\frac{\partial R}{\partial W_{i,j}^{k-1,k}} \right] \\ &= \varepsilon \left[-\frac{\partial R}{\partial I_i^k} \cdot \frac{\partial I_i^k}{\partial W_{i,j}^{k-1,k}} \right] \\ &= \varepsilon \left[-\frac{\partial R}{\partial I_i^k} \right] \cdot O_j^{k-1} \\ &= \varepsilon \cdot \delta_i^k \cdot O_j^{k-1} \end{aligned}$$

$$\begin{aligned} \Delta \theta_{i,j}^{k-1,k} &= \varepsilon \left[-\frac{\partial R}{\partial \theta_{i,j}^{k-1,k}} \right] \\ &= \varepsilon \left[-\frac{\partial R}{\partial I_i^k} \cdot \frac{\partial I_i^k}{\partial \theta_{i,j}^{k-1,k}} \right] \\ &= \varepsilon \left[-\frac{\partial R}{\partial I_i^k} \right] \\ &= \varepsilon \cdot \delta_i^k \end{aligned}$$

FIG. 9A

* IN CASE OF $k = n$
(FINAL STAGE)

$$\begin{aligned} \delta_i^n &= -\frac{\partial R}{\partial I_i^n} \\ &= -\frac{\partial R}{\partial O_i^n} \cdot \frac{\partial O_i^n}{\partial I_i^n} \\ &= (t_i - O_i^n) f'(I_i^n) \end{aligned}$$

* IN CASE OF $k \neq n$

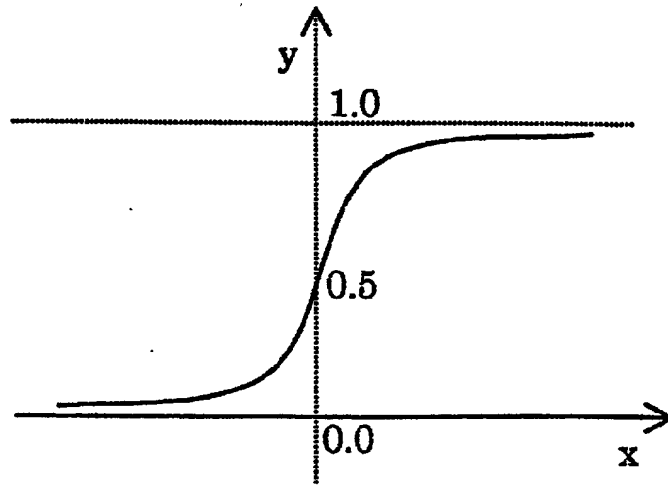
$$\begin{aligned} \delta_i^k &= -\frac{\partial R}{\partial I_i^k} \\ &= -\sum_m \frac{\partial R}{\partial I_m^{k+1}} \cdot \frac{\partial I_m^{k+1}}{\partial O_i^k} \cdot \frac{\partial O_i^k}{\partial I_i^k} \\ &= -\sum_m \frac{\partial R}{\partial I_m^{k+1}} \cdot W_{m,i}^{k,k+1} \cdot f'(I_i^k) \\ &= \sum_m \delta_m^{k+1} W_{m,i}^{k,k+1} f'(I_i^k) \end{aligned}$$

FIG. 9B

$$\Delta W_{i,j}^{k-1,k}(n) = \varepsilon \cdot \delta_i^k \cdot O_j^{k-1} + \alpha \cdot \Delta W_{i,j}^{k-1,k}(n-1)$$

$$\Delta \theta_{i,j}^{k-1,k}(n) = \varepsilon \cdot \delta_i^k + \alpha \cdot \Delta \theta_{i,j}^{k-1,k}(n-1)$$

FIG. 9C



$$f(x) = \frac{1}{1 + \exp(-x)}$$

$$\frac{df(x)}{dx} = f'(x) = f(x) \cdot \{1 - f(x)\}$$

$$\delta_i^n = (t_i - O_i^n) \cdot O_i^n \cdot (1 - O_i^n)$$

$$\delta_i^k = \sum_m \delta_m^{k+1} \cdot W_{m,i}^{k,k+1} \cdot O_i^k \cdot (1 - O_i^k)$$

FIG. 10

$$\Delta W_{i,j}^{k-1,k}(n) = \varepsilon \cdot \delta_i^k \cdot O_j^{k-1} + \alpha \cdot \Delta W_{i,j}^{k-1,k}(n-1) + S$$

$$\Delta \theta_{i,j}^{k-1,k}(n) = \varepsilon \cdot \delta_i^k + \alpha \cdot \Delta \theta_{i,j}^{k-1,k}(n-1) + S$$

$$S = -s \cdot \frac{1}{m} \operatorname{sgn}(W_{i,j}^{k-1,k}(n)) \cdot \left\{ \sum_{i=1}^m |W_{i,j}^{k-1,k}(n)| + |\theta_{i,j}^{k-1,k}(n)| \right\}$$

S: GROWTH CONTROL ITEM

s : GROWTH CONTROL COEFFICIENT

m : NUMBER OF UNITS IN (k-1)TH LAYER

W, θ : WEIGHT, THRESHOLD

$\operatorname{sgn}(x)$: FUNCTION WITH SETTINGS -1 WHEN $x < 0$,
0 WHEN $x = 0$, +1 WHEN $x > 0$

FIG. 11

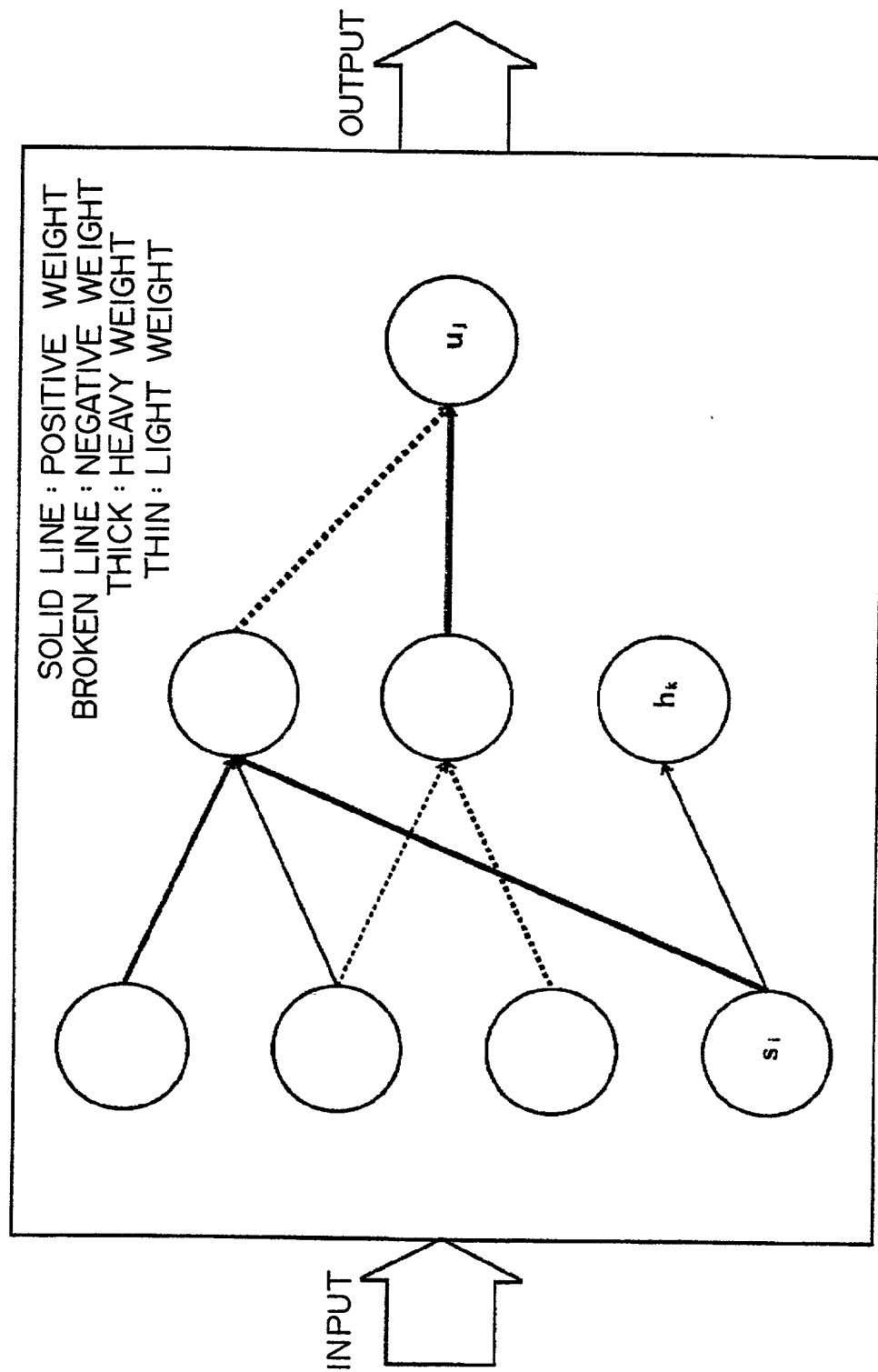


FIG. 12

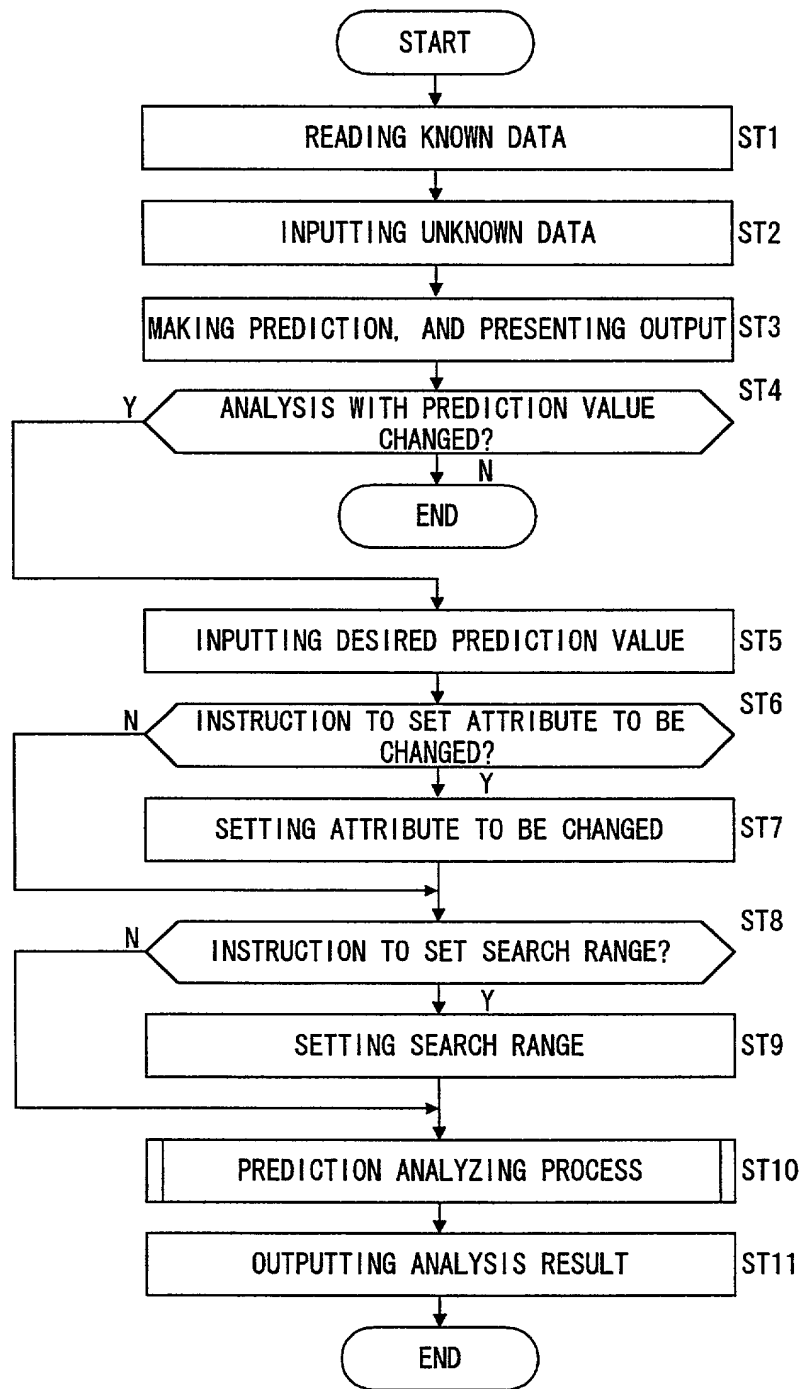


FIG. 13

CHANGE MARK	CHANGE	FIXED	CHANGE	...	
	TEMPERATURE 1	TEMPERATURE 2	PRESSURE	...	RESULT
No. 101	13.8	8.9	1.9	...	?

FIG. 14A

CHANGE MARK	CHANGE	FIXED	CHANGE	...	
MAXIMUM VALUE	20.0	—	2.5	...	
MINIMUM VALUE	10.0	—	1.0	...	
	TEMPERATURE 1	TEMPERATURE 2	PRESSURE	...	RESULT
No. 101	13.8	8.9	1.9	...	?

FIG. 14B

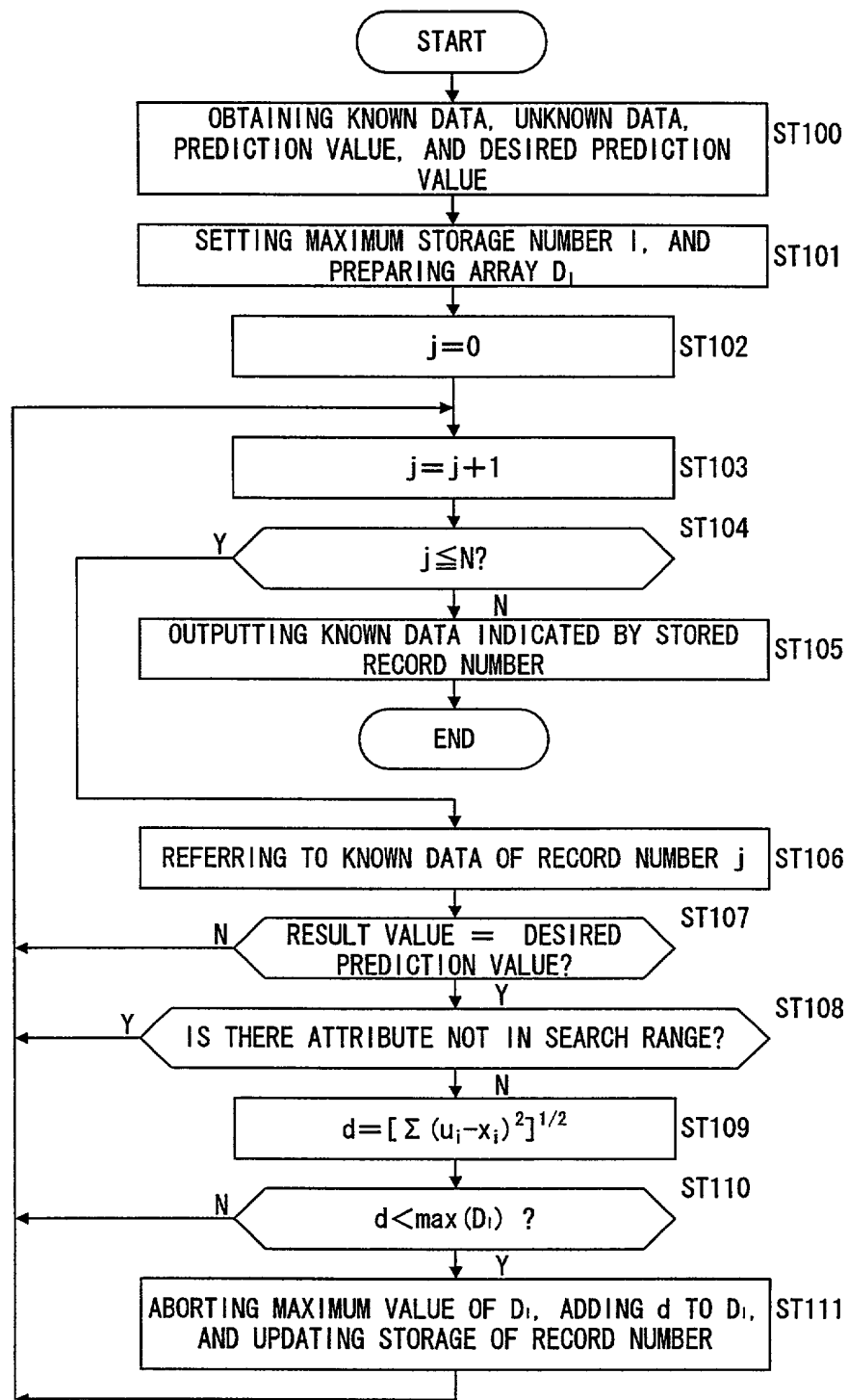


FIG. 15

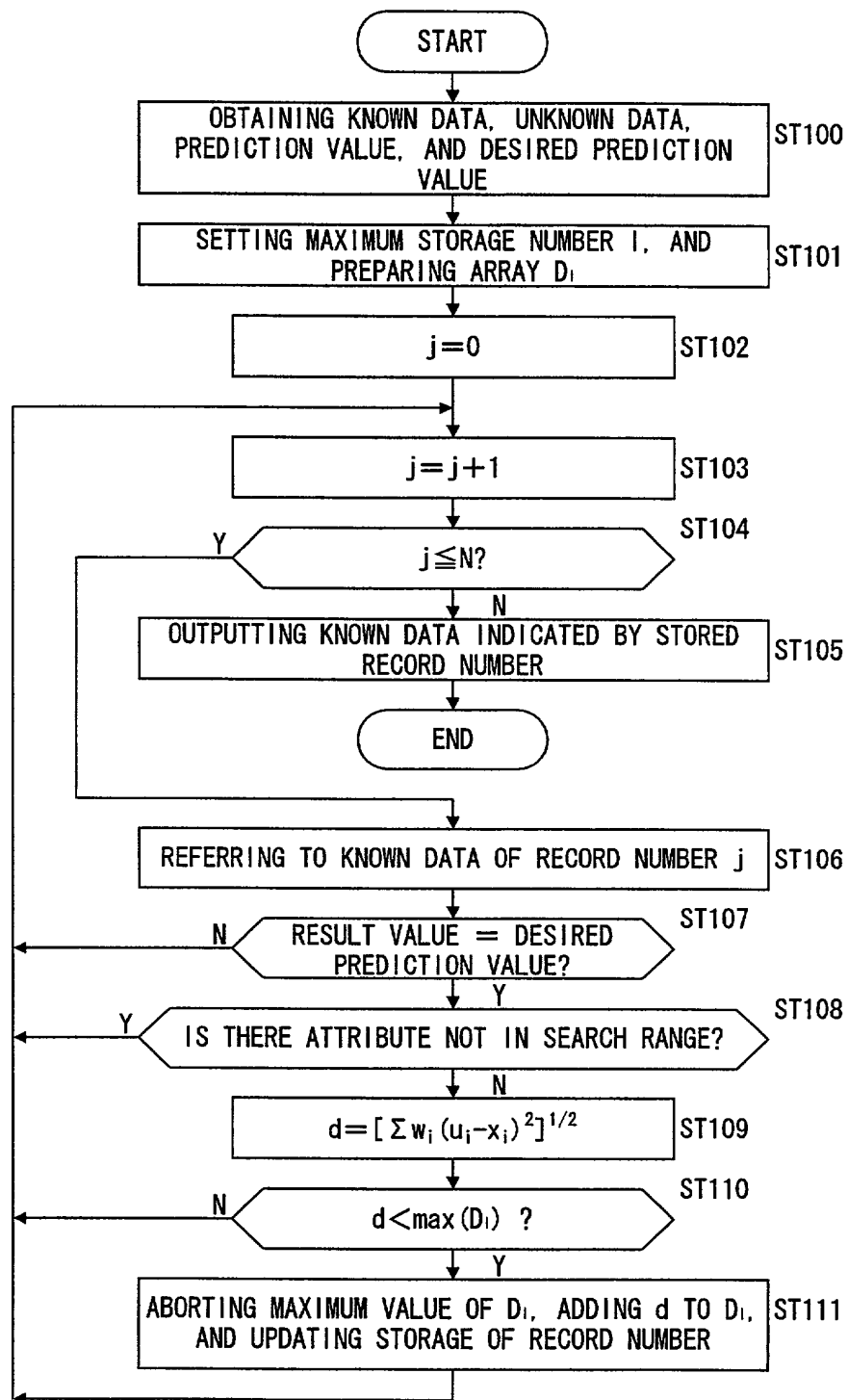


FIG. 16

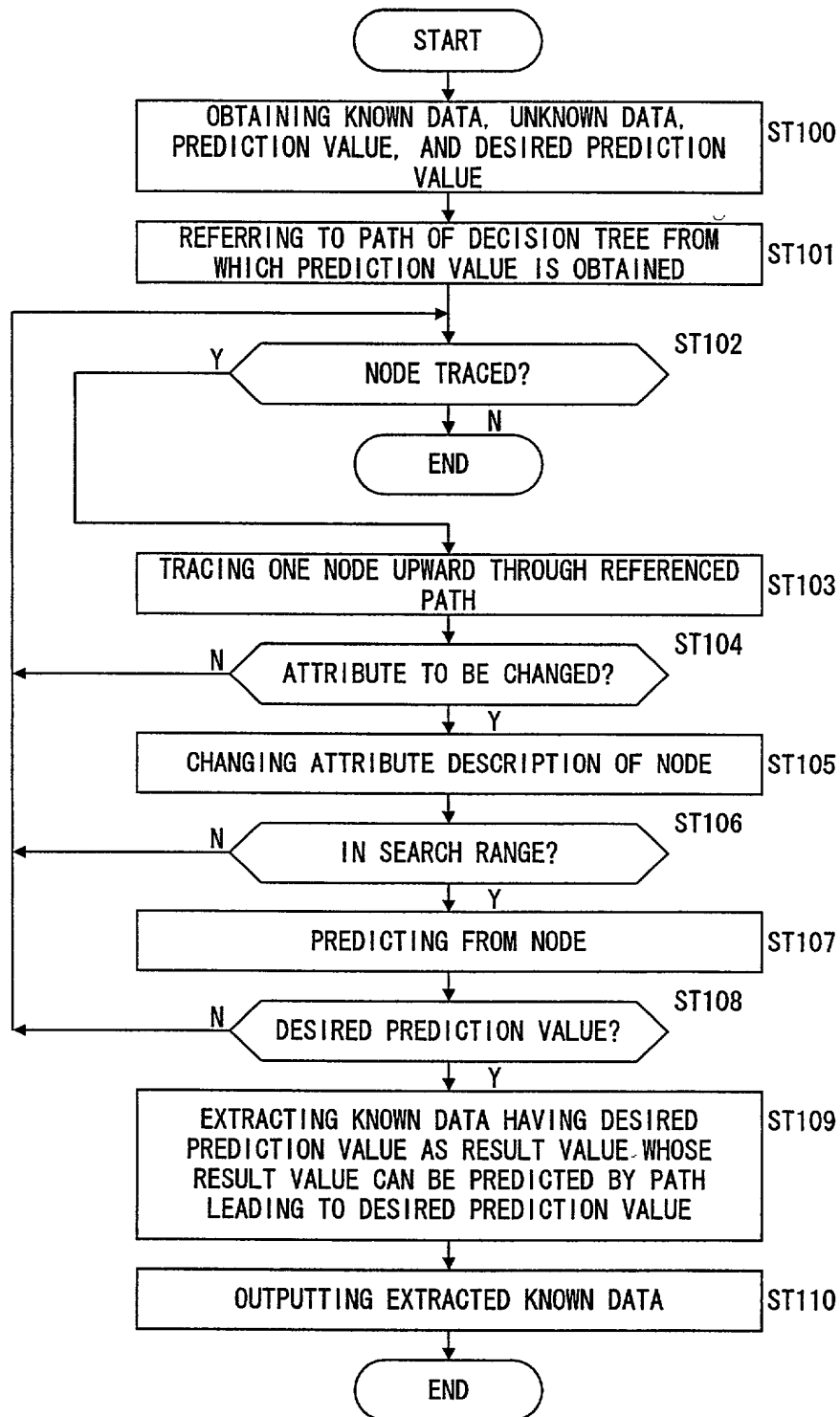


FIG. 17

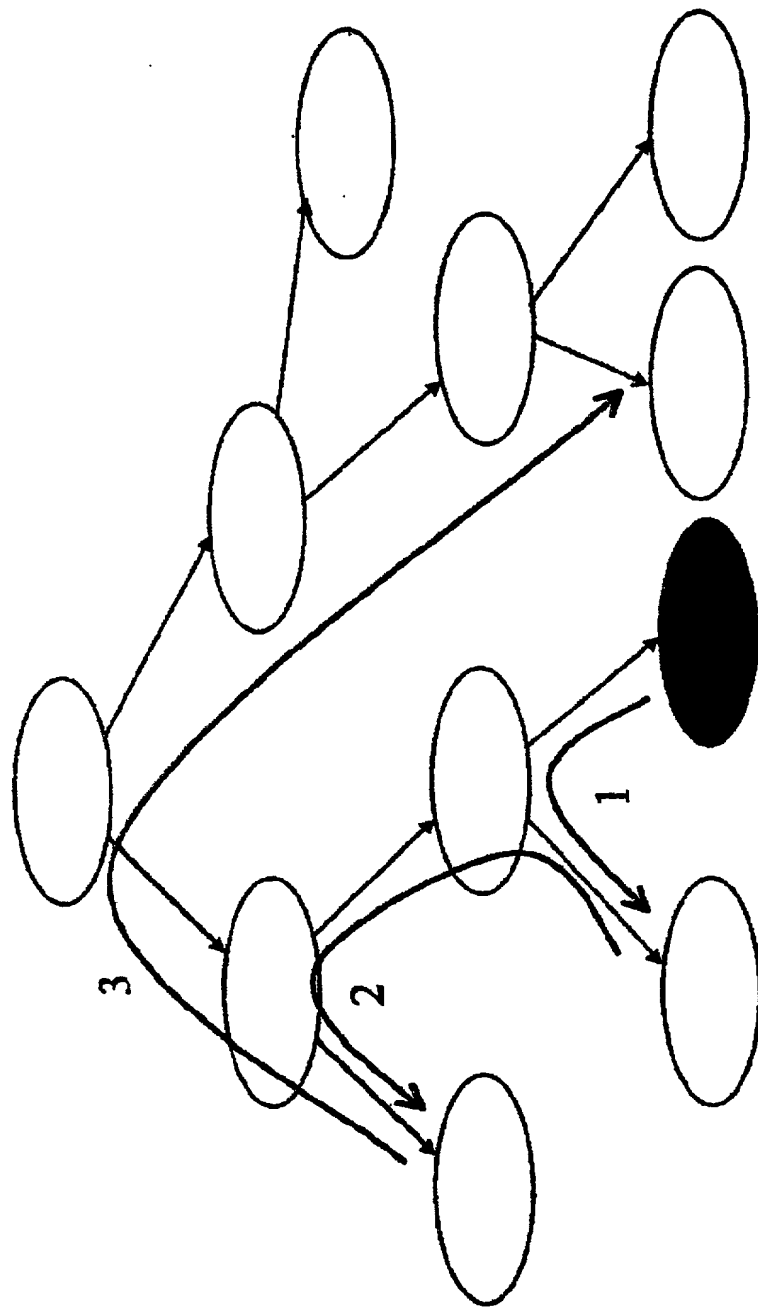


FIG. 18

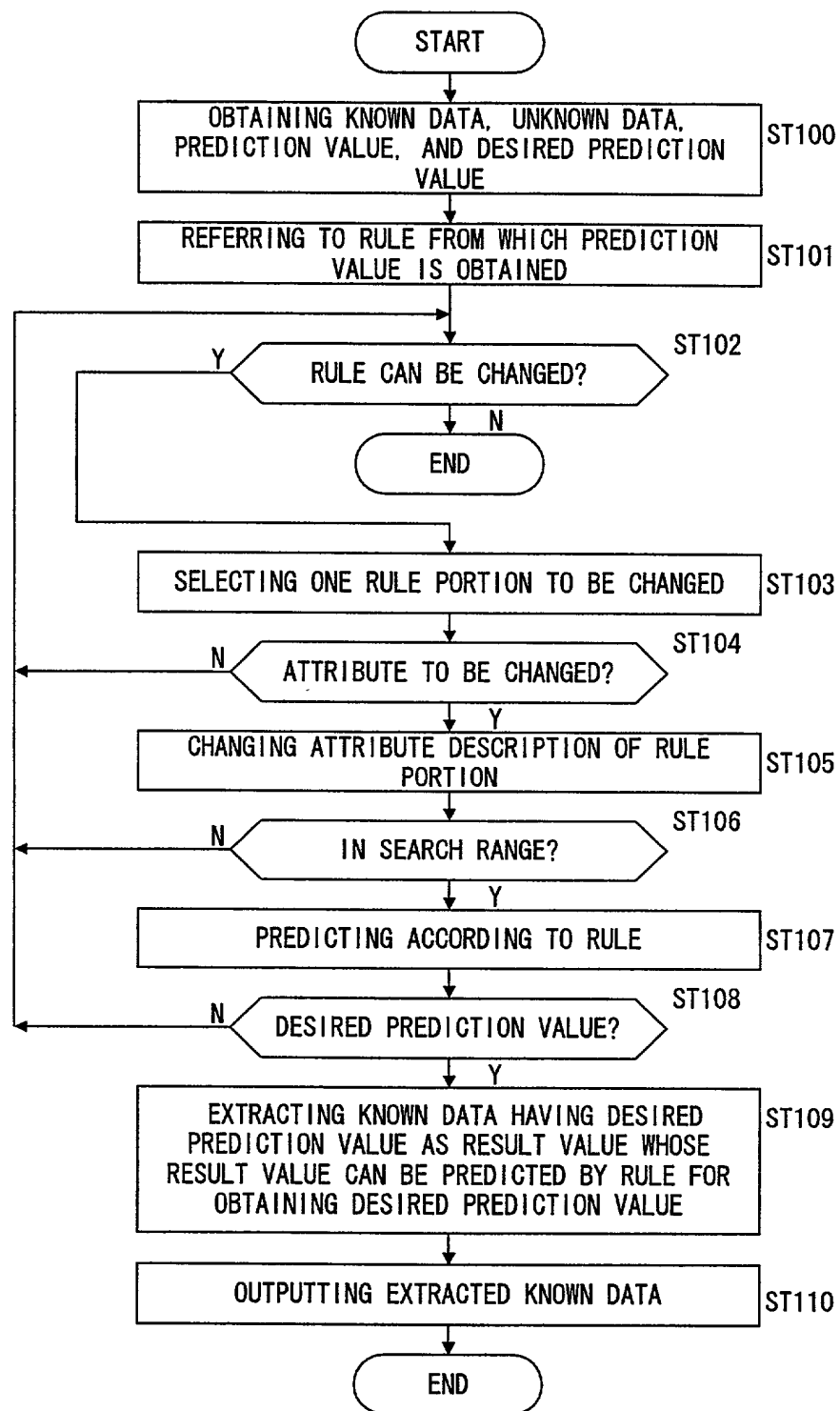
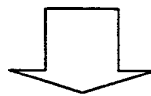


FIG. 19

$[A < 15] \wedge [B \geq 1.4] \wedge [C \geq 10] \wedge [D \geq 3] \rightarrow \text{NG}$

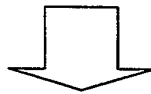
DESIRED PREDICTION VALUE = OK



CHANGING RULE

$[A < 15] \wedge [B \geq 1.4] \wedge [C \geq 10] \wedge [D < 3] \rightarrow \text{OK?}$

NOT DESIRED PREDICTION VALUE



CHANGING RULE

$[A < 15] \wedge [B \geq 1.4] \wedge [C < 10] \rightarrow \text{OK?}$

NOT DESIRED PREDICTION VALUE



CHANGING RULE

$[A < 15] \wedge [B < 1.4] \rightarrow \text{OK?}$

DESIRED PREDICTION VALUE

FIG. 20

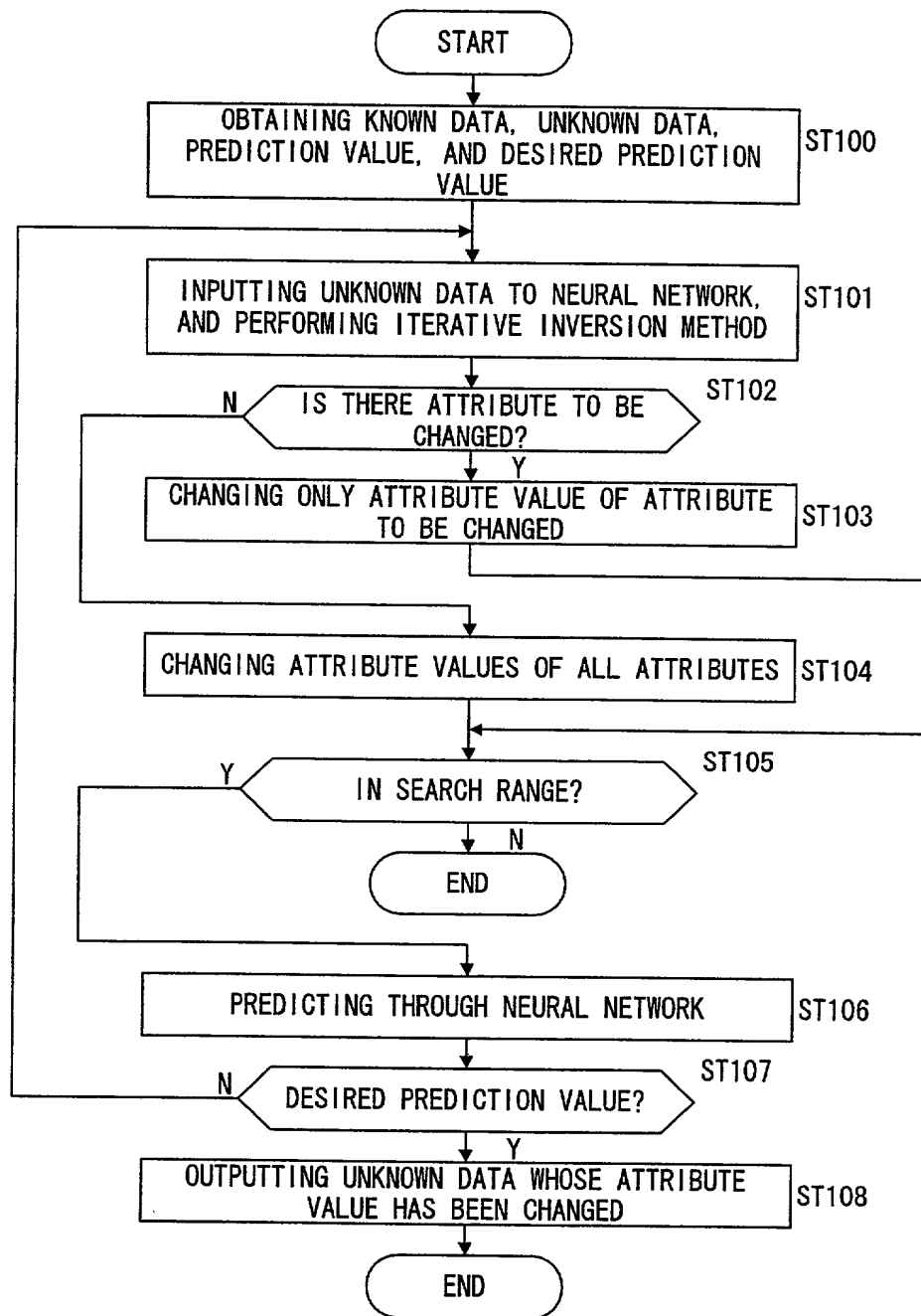
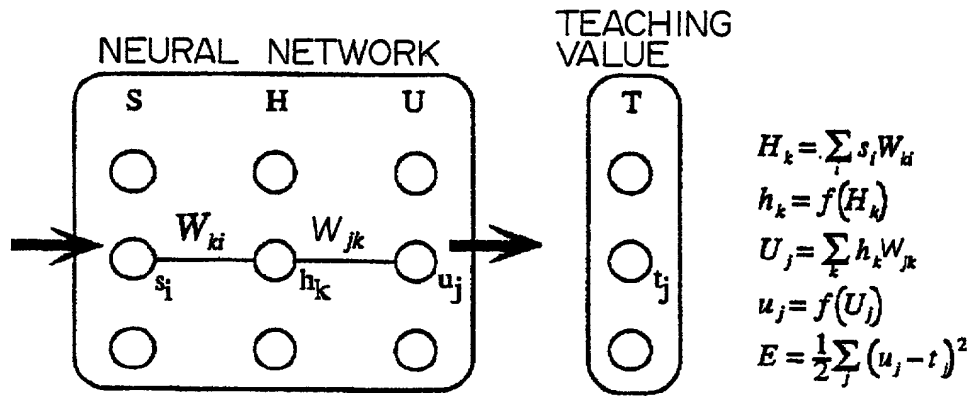


FIG. 21



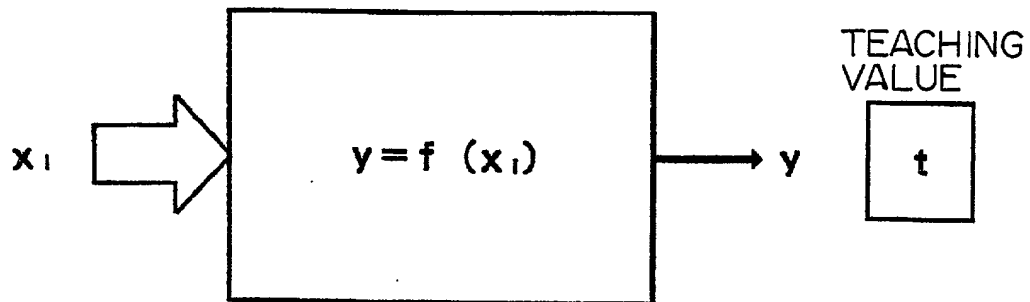
$$s_i \rightarrow s_i + \Delta s_i$$

$$\Delta s_i = \epsilon \left[-\frac{\partial E}{\partial s_i} \right] = \epsilon \left[\sum_j (t_j - u_j) \frac{\partial u_j}{\partial s_i} \right]$$

$$\begin{aligned} \frac{\partial u_j}{\partial s_i} &= \frac{df(U_j)}{dU_j} \frac{\partial U_j}{\partial s_i} \\ &= f'(U_j) \frac{\partial \left(\sum_k h_k W_{jk} \right)}{\partial s_i} \\ &= f'(U_j) \sum_k W_{jk} \frac{\partial h_k}{\partial s_i} \\ &= f'(U_j) \sum_k W_{jk} \frac{df(H_k)}{dH_k} \frac{\partial H_k}{\partial s_i} \\ &= f'(U_j) \sum_k W_{jk} f'(H_k) W_{ki} \end{aligned}$$

$$\Delta s_i = \epsilon \left[\sum_j (t_j - u_j) f'(U_j) \sum_k W_{jk} f'(H_k) W_{ki} \right]$$

FIG. 22



$$E = \frac{1}{2} (y - t)^2$$

$$y = f(x_i) = \sum_i A_i \cdot x_i$$

$$x_i \rightarrow x_i + \Delta x_i$$

$$\Delta x_i = \varepsilon \left[-\frac{\partial E}{\partial x_i} \right] = \varepsilon \left[(t - y) \cdot \frac{\partial y}{\partial x_i} \right]$$

$$\frac{\partial y}{\partial x_i} = \frac{\partial f(x_i)}{\partial x_i} = \frac{\partial \sum_i A_i \cdot x_i}{\partial x_i} = A_i$$

$$\therefore \Delta x_i = \varepsilon [(t - y) \cdot A_i]$$

FIG. 23